

Work Order ID 90223-3

September-14-12 9:53:30 AM

Split

ASAP

90223

Page 1

Item ID: D3439-101

Revision ID:

Item Name: Mirror Assembly 8"

Start Date: 9/14/12 Start Qty: 20.00

Required Date: 10/12/12 Req'd Qty: 20.00

Reference:

Accept

N9000040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan: *HLJ*
QC:

Date: *12-09-17* Tooling:

Date: SPC (Y/N):

Date:

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours
--------------------------------	--------------------------	----------------------

Draw Nbr	Revision Nbr
----------	--------------

D3439	Rev B
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100

100

Purchasing

Purchasing

PURCHASING

Memo

Issue P/O:

For Grote Mirror P/N: 12183

Possible Supplier: UAP/NAPA

Material release note is required

0.00

0.00

110

110

Packaging

Packaging

Receive & Inspect for Damage & Mat'l Certs

0.00

Memo

Ensure Material Release Note is attached

0.00

115

115

QC

Quality Control

QC6- Inspect dimensions to drawing

0.00

Memo

0.00

DAV
10
12/14

12/14/12
HLJ
12/14/12



Work Order ID 90223

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Page 2

Item ID: D3439-101

Revision ID:

Item Name: Mirror Assembly 8"

Start Date: 9/14/12 Start Qty: 20.00

Required Date: 10/12/12 Req'd Qty: 20.00

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan:

QC:

Date:

Tooling:

Date:

Run Start *NR1*

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

120

120

Small Fab

Small Fab

Operation
Description

Small Fab

Memo

1- Discard Hardware
2- Drill and Tap mirror as per Dwg using DT9670 , then install stud as per dwg.
3- Plug drain holes with Sikaflex.
Ensure that mirror adheres to housing.

Pick:

Qty Part Number Description Batch

A/RN/A Sikaflex-241/-291 M123914

Sikaflex expiry date 13/06/22

Set Up/
Run Hours

0.00

0.00

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

130

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

DAS
15
9-39
13.2 22

1X
13/02/20

J



Work Order ID 90223

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90223

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Item ID: D3439-101

Revision ID:

Item Name: Mirror Assembly 8"

Start Date: 9/14/12 Start Qty: 20.00

Required Date: 10/12/12 Req'd Qty: 20.00

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

140

Identify as per dwg & Stock Location: _____

0.00

140

Packaging

Memo

SNIP

0.00

Packaging

13/2/26 ①

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

MC 13-02-26

MC
13-2-26



Picklist Print

September-14-12 9:53:29 AM

Page 1

Work Order ID: 90223
 Parent Item: D3439-101
 Parent Item Name: Mirror Assembly 8"

Start Date: 9/14/12
 Start Qty: 20.00

Required Date: 10/12/12
 Required Qty: 20.00

Comments: IPP A05.07.20New issueKJ/JLM ver:ec IPP Rev:B 10.09.08 per dwg RevB DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
12183 GROTE MIRROR		Purchased	No			120	Each	20.0000	1	20			

Location	Loc Qty	Loc Code
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ST	20	
86978	20	

D3015-3 Locknut	Manufactured	No			120	Each	332.0000	1	20			
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Location	Loc Qty	Loc Code
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ST023	332	
78314	38	
83565	294	

D3439-3 Stud	Manufactured	No			120	Each	50.0000	1	20			
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Location	Loc Qty	Loc Code
----------	---------	----------

GA	50	
77048	6	
83077	44	

NAS1149C0563R Washer	Purchased	No			120	Each	328.0000	1	20			
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Location	Loc Qty	Loc Code
----------	---------	----------

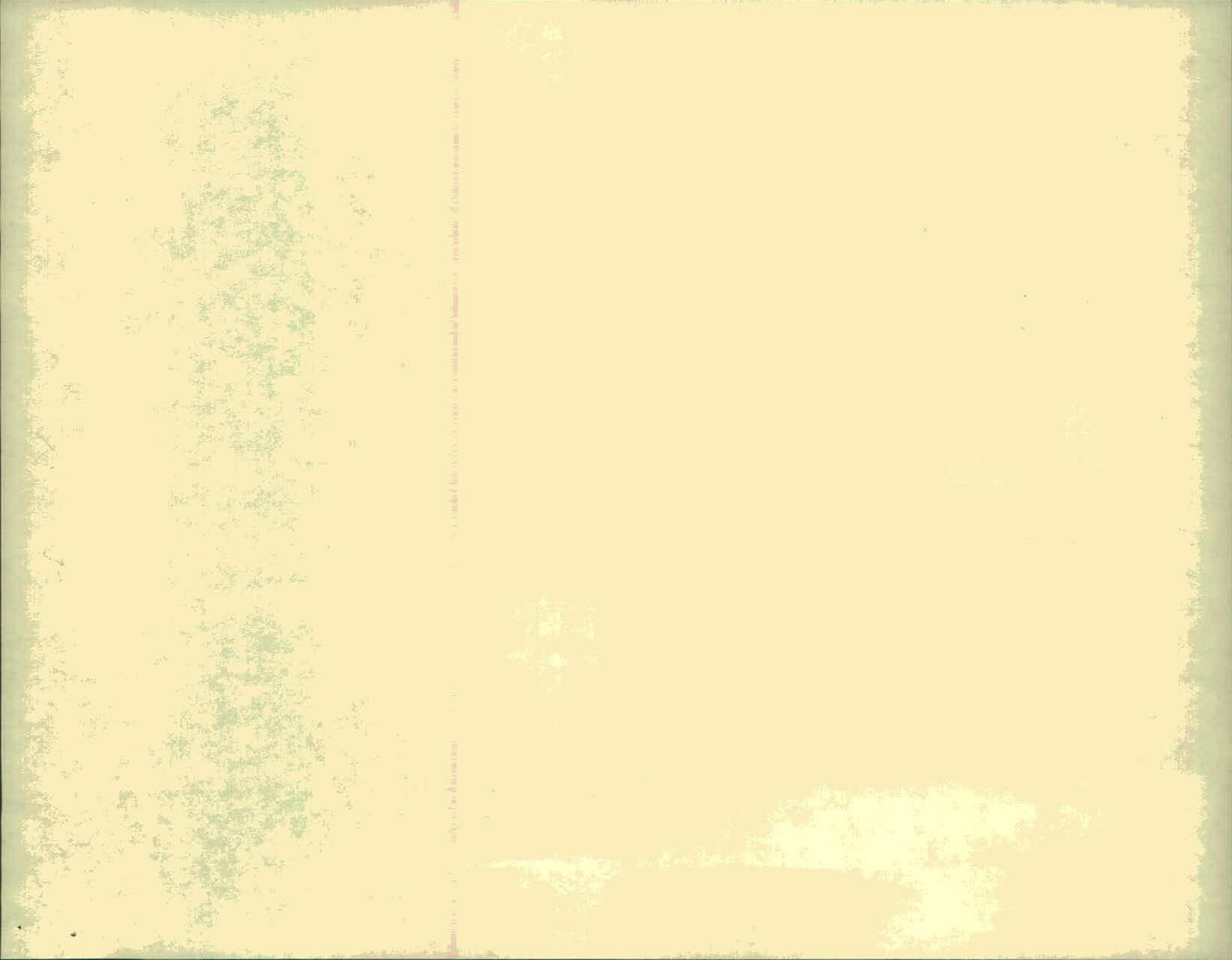
ST296	200	
120422	200	
ST297	128	
116391	8	
117460	120	

6/12/15 90223

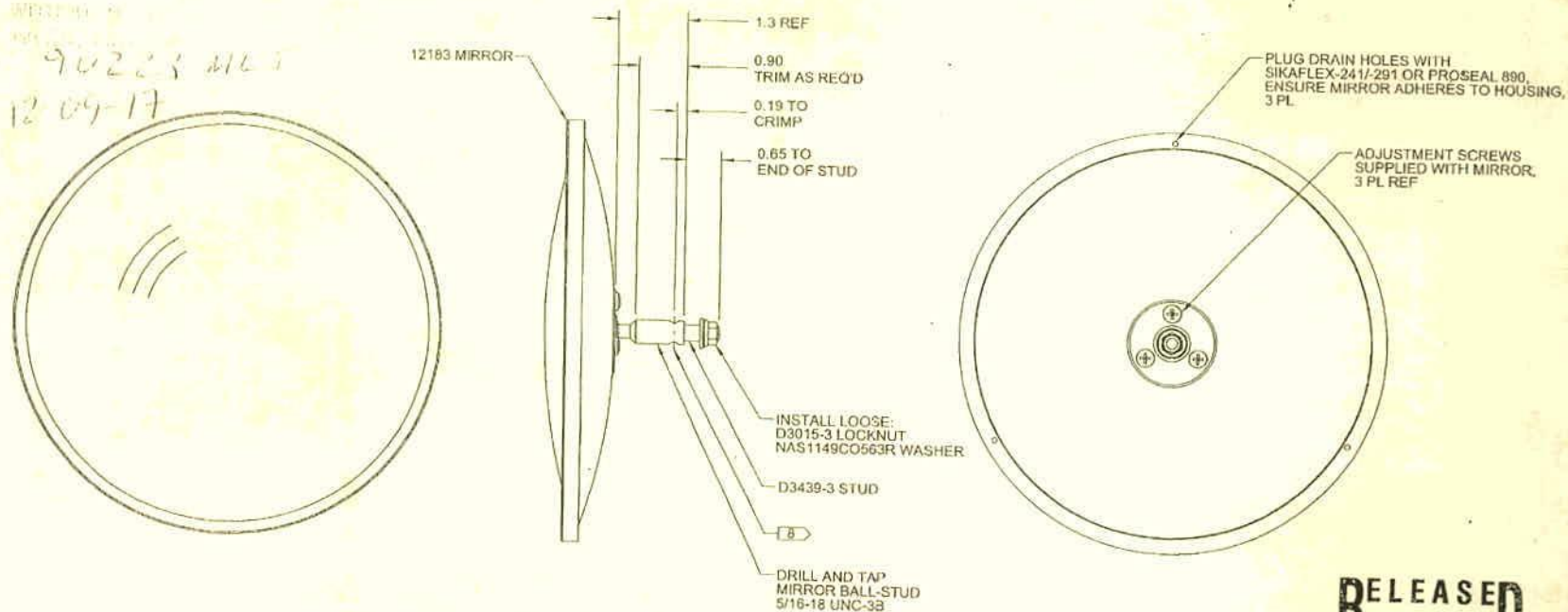
6/13/12/26

6/13/12/26

6/13/12/26



ITEM	QTY -101	P/N	DESCRIPTION
1	X	D3439-101	MIRROR ASSEMBLY, 8"
2	1	12183	MIRROR 8" (GROTE)
3	1	D3015-3	LOCKNUT
4	1	D3439-3	STUD
5	1	NAS1149CO563R	WASHER (OR AN960JD516)



D3439-101 MIRROR ASSEMBLY

NOTES:

- 1) MATERIAL: MIRROR= 8" ROUND CONVEX MIRROR W/ STAINLESS STEEL CASE
CENTER-MOUNT BALL-STUD W/ 1/4-20 X 1" DEEP FEMALE THREAD
GROTE INDUSTRIES, 2600 LANIER DRIVE, MADISON, INDIANA 47250
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3439-101" USING REMOVEABLE TAG
- 7) WEIGHT: 1.18 lbs
- 8) TO INSTALL D3439-3 STUD:
 - APPLY LOCKTITE 262 TO THREADS BEING INSTALLED INTO MIRROR BALL-STUD
 - THREAD D3439-3 STUD INTO MIRROR BALL-STUD
 - CRIMP MIRROR BALL-STUD ON OPPOSING SIDES, 0.19 FROM END AS ILLUSTRATED USING TOOL DT8317
 - CRIMP TO DEPTH OF 0.015-0.030 USING R0.125

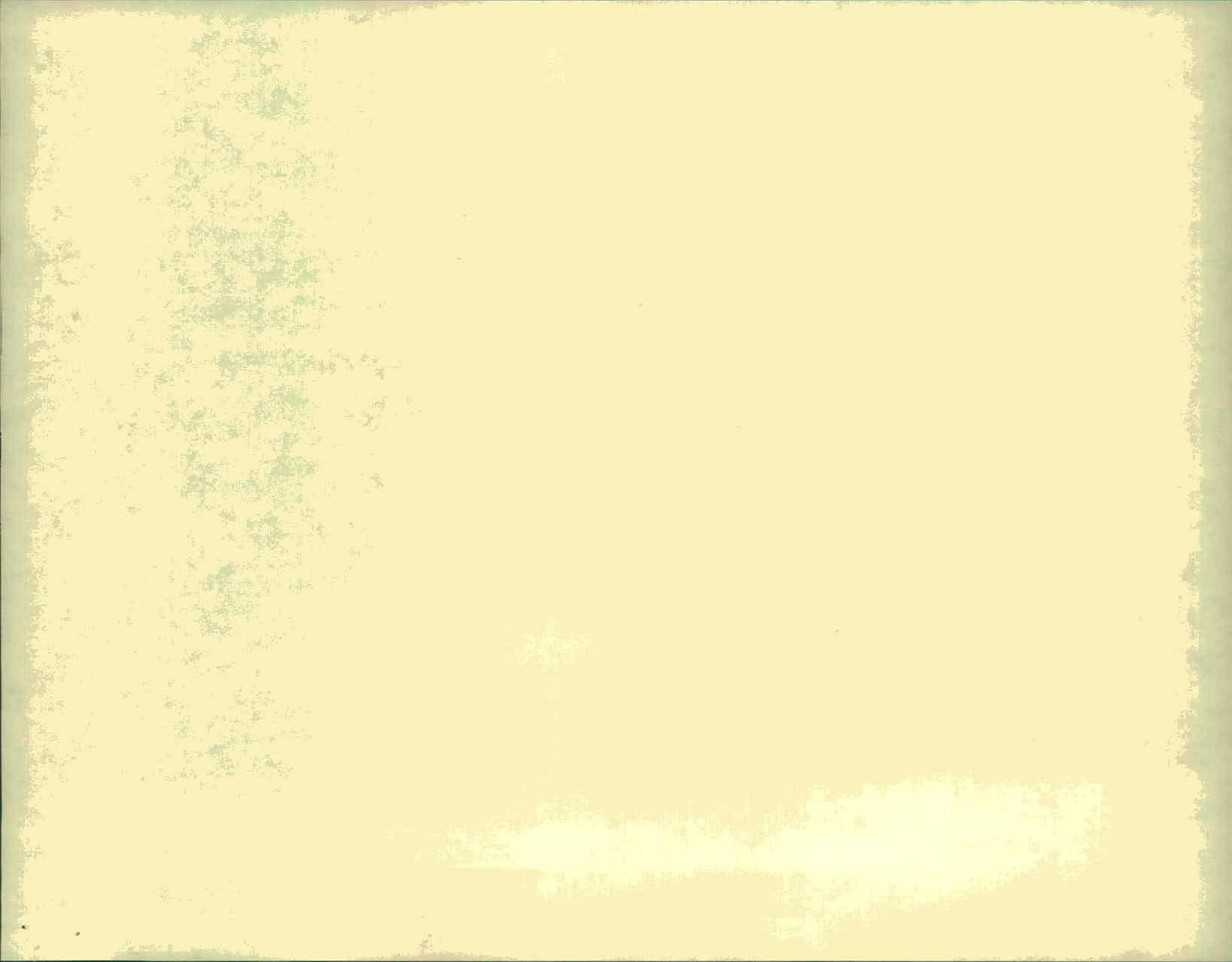
RELEASED
2010-09-07

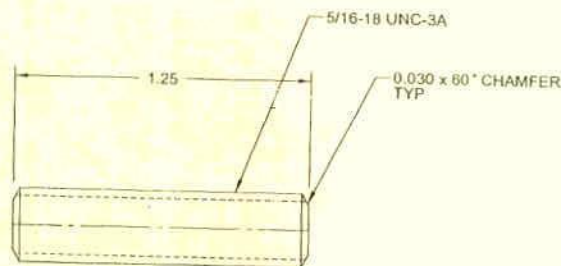
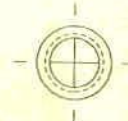
B	REDRAW, ADD -3 (WAS PURCHASED/TRIMMED BOLT), RMV LIPS	CP	10.07.20
A	NEW ISSUE	CP	05.05.27
REV.	DESCRIPTION	BY	DATE
DESIGN	gp		
DRAWN	gp		
CHECKED	gp		
MFG. APPR.	gp		
APPROVED	gp		
DE APPR.	gp		
DATE	10.07.20		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3439** REV. B
SHEET 1 OF 2
TITLE **MIRROR ASSEMBLY** SCALE NTS

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D3439-3 STUD

NOTES:

- 1) MATERIAL: AISI 303 STAINLESS STEEL ROUND BAR PER ASTM A582
REF DART SPEC M303R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.03 lbs

RELEASED
2010-09-07

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3439	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		MIRROR ASSEMBLY	NTS
DATE	10.07.20	<small> COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND UNRESTRICTED. IT IS THE PROPERTY OF DART AEROSPACE LTD. IT IS TO BE USED FOR THE PURPOSES FOR WHICH IT WAS ISSUED AND NOT BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD. </small>	

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO17917

Purchase Order Date 9/17/12

PO Print Date 9/17/12

Page Number 1 of 1

Order From :

VC-UAP001

UAP HAWKESBURY INC. #074
514 MAIN STREET WEST
HAWKESBURY, ON K6A 2J2
CA

Contact Name

Vendor Phone

613 632 8575

Vendor Fax

613 632 1539

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FXED
9/17/12

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	12183	GROTE MIRROR	9/19/12 Yes	20.00 Each	Yours ppd	\$21.4900	\$429.80

Special Inst: AS PER DWG D3439 REV. B
B90223
GROTE P/N: 12183

PO Total:

\$429.80

CERTIFICATE OF CONFORMITY
REQD UPON DELIVERY

No substitution or deviation without
consent.

Certificate of Conformity or Material
Certification required - YES NO

Change Nbr: 1

Change Date: 9/17/12



